# Work Order ID 122949

*122949*

*Tuesday, July 29, 2014 2:26:42 PM*



**Item ID:** D4091-1 **Accept** *N9000040100* **Setup Start** *NS1*

**Revision ID:** **Stop** *NS2*

**Item Name:** Mounting Lug

**Start Date:** 7/24/14 **Start Qty:** 20.00 *20*

**Required Date:** 7/29/14 **Req'd Qty:** 20.00 *20*

**Reference:**

**Cust Item ID:**

**Customer:**

**Run Start** *NR1*

**Stop** *NR2*

**Approvals:** **Process Plan:** WM **Date:** 7/30/14 **Tooling:** _____ **Date:** _____

**QC:** _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

| Draw Nbr | Revision Nbr |
|---|---|
| D4091 | A |

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|---|---|---|---|---|---|---|---|---|
| 100 | | 0.00 | | | | | | | |
| *100* | | | | | | | | | |
| Outsource5 | **Memo** | 0.00 | | | | | | | |
| Outsource process - Machining | ISSUE PO TO METEC: 25276 | | | | | | | | |
| | C OF C IS REQUIRED | | | | | | | | |
| | Received → SP 14-8-18 20X | | | | | | | | |
| 130 | QC6- Inspect dimensions to drawing | 0.00 | | | | | | | |
| *130* | | | | | | | | | |
| QC | **Memo** | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |
| 140 | Chemical Conversion Coat per QSI005 4.1 | 0.00 | | | | | | | |
| *140* | | | | | | | | | |
| HandFinish | **Memo** | 0.00 | | | | | | | |
| Hand Finishing | | | | | | | | | |

CL 14/08/01 20

(20) DAS 9 9-89 DAS 38 9-89 14/08/18

20 MBuck 8-19

DQA: _____ Date: _____

DART AEROSPACE

# WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

**DISPOSITION**

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

**AGAINST DEPARTMENT/PROCESS**

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

| Root Cause | | Date | Step | Qty | Description of work order update or non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---|---|---|---|---|---|---|---|---|---|---|
| Design | ☐ | | | | | | | | | |
| Doc/Data | ☐ | | | | | | | | | |
| Equip/Tooling | ☐ | | | | | | | | | |
| Handling/Pre | ☐ | | | | | | | | | |
| Material | ☐ | | | | | | | | | |
| Operator | ☐ | | | | | | | | | |
| Offset/Setup | ☐ | | | | | | | | | |
| Process | ☐ | | | | | | | | | |
| Supplier | ☐ | | | | | | | | | |
| Training | ☐ | | | | | | | | | |
| Transport | ☐ | | | | | | | | | |
| Unapproved | ☐ | | | | | | | | | |

**FAULT CATEGORY**

**Landing Gear**

☐ Bending
☐ Centre Not Concentric
☐ Cracks
☐ Crimp/Kink/Ripple/Wave
☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

**General**

☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
☐ Finish
☐ Fit/Function

☐ Folio/Program
☐ Grain
☐ Hardware
☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
☐ Misaligned/off center
☐ Mislabeled
☐ Misread
☐ Off-set
☐ Out of Calibration
☐ Out of Sequence

☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge

☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled

☐ Other

_____
_____
_____

**Item ID:** D4091-1 **Accept** *N9000040100* **Setup Start** *NS1*
**Revision ID:** **Stop** *NS2*
**Item Name:** Mounting Lug

**Start Date:** 7/24/14 **Start Qty:** 20.00 *20* **Cust Item ID:**
**Required Date:** 7/29/14 **Req'd Qty:** 20.00 *20* **Customer:**
**Reference:**

**Run Start** *NR1*
**Stop** *NR2*

**Approvals:** **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
**QC:** _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|---|---|---|---|---|---|---|---|---|
| 150 | White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum | 0.00 | | | | | | | |
| *150* | M128959 START: 1:25. OVEN T: 320 FINISH: 1:55 | | | | | 20 | 0 | 14-8-19 | DAS 34 9-89 |
| Powdercoat | **Memo** | 0.00 | | | | | | | |
| Powder Coating | | | | | | | | | |
| 160 | QC3- Inspect Part Finish | 0.00 | | | | | | | |
| *160* | | | | | | 20 | ✓ | DP | 14/08/19. |
| QC | **Memo** | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |
| 170 | Identify as per dwg & Stock Location: ST538 | 0.00 | | | | | | | |
| *170* | | | | | | 20X | | DAS 28 9-89 | AUG 2 0 2014 |
| Packaging | **Memo** | 0.00 | | | | | | | |
| Packaging | | | | | | | | | |

DQA: _____ Date: _____

DART AEROSPACE

# WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

**DISPOSITION**

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Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

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Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

| Root Cause | | Date | Step | Qty | Description of work order update or non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---|---|---|---|---|---|---|---|---|---|---|
| Design | ☐ | | | | | | | | | |
| Doc/Data | ☐ | | | | | | | | | |
| Equip/Tooling | ☐ | | | | | | | | | |
| Handling/Pre | ☐ | | | | | | | | | |
| Material | ☐ | | | | | | | | | |
| Operator | ☐ | | | | | | | | | |
| Offset/Setup | ☐ | | | | | | | | | |
| Process | ☐ | | | | | | | | | |
| Supplier | ☐ | | | | | | | | | |
| Training | ☐ | | | | | | | | | |
| Transport | ☐ | | | | | | | | | |
| Unapproved | ☐ | | | | | | | | | |

**FAULT CATEGORY**

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☐ Marks/Chatter
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☐ Countersink
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☐ Fit/Function
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☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

_____
_____
_____

**Item ID:** D4091-1 **Accept** *N900040100* **Setup Start** *NS1*
**Revision ID:** **Stop** *NS2*
**Item Name:** Mounting Lug

**Start Date:** 7/24/14 **Start Qty:** 20.00 *20* **Cust Item ID:**
**Required Date:** 7/29/14 **Req'd Qty:** 20.00 *20* **Customer:**
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**Run Start** *NR1*
**Stop** *NR2*

**Approvals:** **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
**QC:** _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|---|---|---|---|---|---|---|---|---|
| 180 | QC21- Final Inspection - Work Order Release | 0.00 | | | | | | | |
| *180* | | | | | | MCJ | 14-08-21 | | |
| QC | **Memo** | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

14-8-21

DQA: _____ Date: _____

DART AEROSPACE

# WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

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Use-as-is ☐
Suspected Unapproved ☐

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Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

| Root Cause | | Date | Step | Qty | Description of work order update or non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---|---|---|---|---|---|---|---|---|---|---|
| Design | ☐ | | | | | | | | | |
| Doc/Data | ☐ | | | | | | | | | |
| Equip/Tooling | ☐ | | | | | | | | | |
| Handling/Pre | ☐ | | | | | | | | | |
| Material | ☐ | | | | | | | | | |
| Operator | ☐ | | | | | | | | | |
| Offset/Setup | ☐ | | | | | | | | | |
| Process | ☐ | | | | | | | | | |
| Supplier | ☐ | | | | | | | | | |
| Training | ☐ | | | | | | | | | |
| Transport | ☐ | | | | | | | | | |
| Unapproved | ☐ | | | | | | | | | |

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☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled

☐ Other

_____
_____
_____

# Picklist Print



*Tuesday, July 29, 2014 2:26:42 PM*

**Work Order ID:** 122949 *122949*

**Parent Item:** D4091-1 *D4091-1*

**Parent Item Name:** Mounting Lug

**Start Date:** 7/24/14 **Required Date:** 7/29/14

**Start Qty:** 20.00 **Required Qty:** 20.00

**Comments:** IPP REV :A NEW ISSUE 10-03-31 JLM VERIFIED BY:EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| D2423 | | Manufactured | No | | | | f | 267.1160 | | 3 | | | |
| *D2423* | | | | | | | | | ** | | CL 14/08/01 | | |
| Lug Extrusion | | | | | | | | | | | | | |

| Location | Loc Qty | Loc Code |
|---|---|---|
| HALL | 267.116 | |
| 115529 | 267.116 | |

3

D4691-1P

X 20

CL 13108118

DQA: _____ Date: _____

DART AEROSPACE

# WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

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NCR No. _____

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| Doc/Data | ☐ | | | | | | | | | |
| Equip/Tooling | ☐ | | | | | | | | | |
| Handling/Pre | ☐ | | | | | | | | | |
| Material | ☐ | | | | | | | | | |
| Operator | ☐ | | | | | | | | | |
| Offset/Setup | ☐ | | | | | | | | | |
| Process | ☐ | | | | | | | | | |
| Supplier | ☐ | | | | | | | | | |
| Training | ☐ | | | | | | | | | |
| Transport | ☐ | | | | | | | | | |
| Unapproved | ☐ | | | | | | | | | |

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☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
☐ Misaligned/off center
☐ Mislabeled
☐ Misread
☐ Off-set
☐ Out of Calibration
☐ Out of Sequence

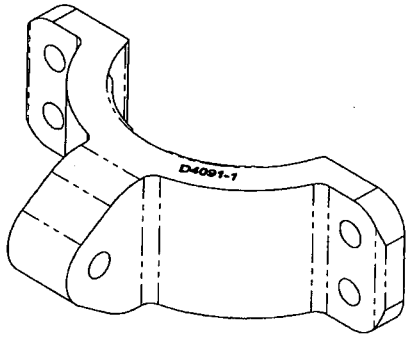
☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge

☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled

☐ Other

_____
_____
_____

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 129949
7/30/14 wm




**D4091-1 MOUNTING LUG**

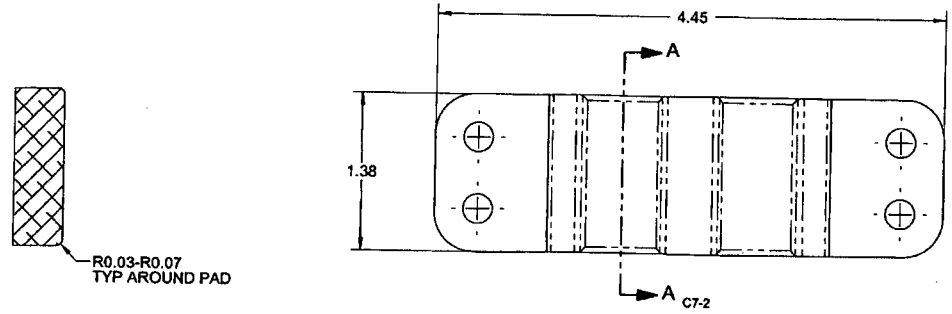
RELEASED
2010-04-28

NOTES:
1) MATERIAL: MAKE FROM D2423 EXTRUSION
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010 ± 0.005 IN THIS LOCATION WITH A TOOL TIP RADIUS OF 0.015 ± 0.005
7) WEIGHT: 0.31 lbs

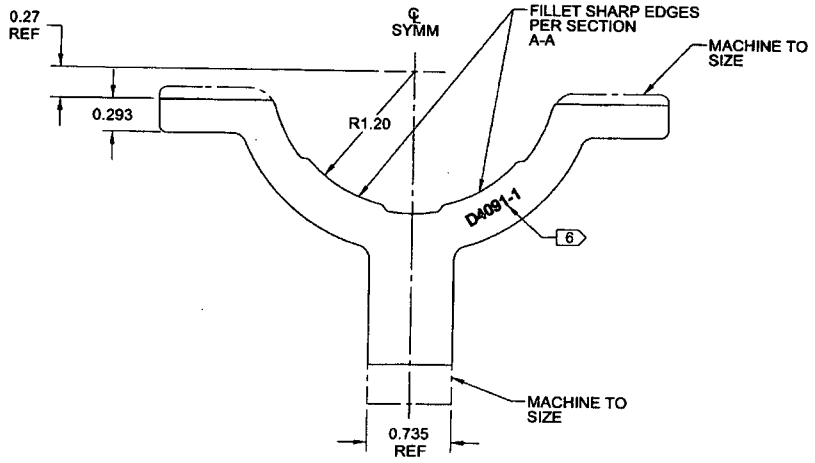
| REV. | DESCRIPTION | BY | DATE |
|---|---|---|---|
| A | NEW ISSUE | CP | 10.03.29 |

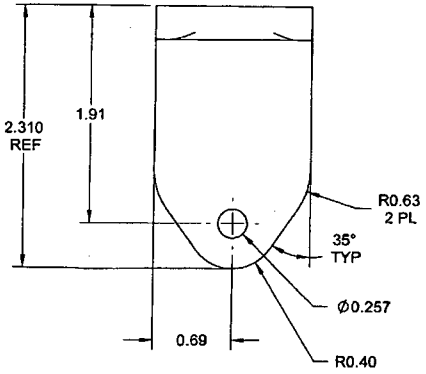
| | | |
|---|---|---|
| DESIGN | CP | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |
| DRAWN | CP | |
| CHECKED | | DRAWING NO. D4091 REV. A |
| MFG. APPR. | | SHEET 1 OF 2 |
| APPROVED | | TITLE MOUNTING LUG SCALE NTS |
| DE APPR. | | |
| DATE | 10.03.29 | |

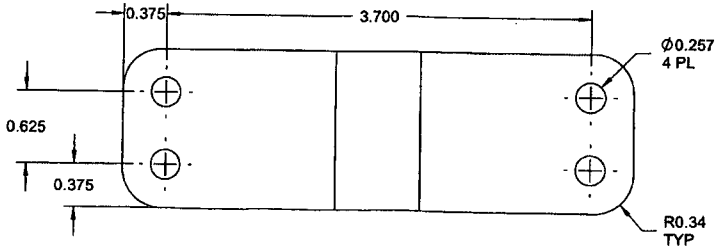
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**SECTION A-A** C5-2




**D4091-1 MOUNTING LUG**

RELEASED
2010-04-20

| | | |
|---|---|---|
| DESIGN | CP | DART AEROSPACE LTD |
| DRAWN | CP | HAWKESBURY, ONTARIO, CANADA |
| CHECKED | | DRAWING NO. D4091 REV. A |
| MFG. APPR. | | SHEET 2 OF 2 |
| APPROVED | | TITLE MOUNTING LUG SCALE NTS |
| DE APPR. | | |
| DATE | 10.03.29 | |

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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

# PURCHASE ORDER

**Purchase Order ID PO25276**

**Purchase Order Date** 8/1/2014
**PO Print Date** 8/1/2014



**Order From :** VC-MET003

METEC METAL TECHNOLOGY INC.
20 TERRY FOX DRIVE PO BOX 781
VANKLEEK HILL, ON K0B 1R0
CA

**Ship To :** DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

| | | | |
|---|---|---|---|
| **Contact Name** | | **Buyer** | Chantal Lavoie |
| **Vendor Phone** | 613 678 3957 | **Customer POID** | |
| | | **Customer Tax #** | 10127-2607 |
| **Ship To Contact** | | **Terms** | Net 10 |
| **Ship To Phone** | | **Currency** | CAD |
| **Ship Via:** | Dart Truck | **FOB** | Destination-Collect |
| **Ship Acct:** | | | |

| Line Nbr | Reference / Vendor Part Number / Line Comments / Delivery Comments | Description/ Mfg ID | Req Date/ Taxable / Promise Date | CD | Req Qty/ Unit of Measure | PO Unit Price | Extende Pri |
|---|---|---|---|---|---|---|---|
| 1 | D4091-1P | Lug | 8/15/2014<br>Yes<br>8/15/2014 | | 20.00<br>Each | $26.95 | $539.( |
| | AS PER DWG D4091 REV. A<br>B122949 | | | | | | |
| | | | | | | **Line Total:** | **$539.(** |
| 2 | 71401-45 | PROCUREMENT QUALITY CLAUSES | 8/15/2014<br>No<br>8/15/2014 | | 1.00 | $0.00 | $0.( |
| | Procurement Quality Clauses<br>A004 faa-pma/tso<br>A005 right of entry<br>A007 first article inspection<br>A016 personnel qualification<br>A026 certification of materila conformance<br>A040 notification of escape clauses<br>A042 dart notification by supplier<br>A043 retention of quality document | | | | | | |

SP 14-8-18.

**Note:**

METEC METAL TECHNOLOGY INC.
20 Terry Fox Drive
Vankleek Hill, Ontario K0B 1R0 , Canada
Tel: (613) 678-3957
Fax: (613) 678-3956

**Delivery Slip No.:** **20072**
Date: Aug 14, 2014
Page: 1

| **Sold to:** | **Ship to:** |
|---|---|
| **Dart Aerospace Ltd.**<br>Att. Micheal Gregoire<br>1270 Aberdeen Street<br>Hawkesbury, Ontario K6A 1K7 | Dart Aerospace Ltd.<br>Att. Micheal Gregoire<br>1270 Aberdeen Street<br>Hawkesbury, Ontario K6A 1K7 |
| **Order No.:** 25276 | **Sold By:** Dewar, Eric |
| **Shipped By:** your truck | **Ship Date:** Aug 14, 2014 |

| Description | Unit | Ordered quantity | Shipped quantity | Backorder quantity |
|---|---|---|---|---|
| D4091-1 Lug as per drawing D4091 Rev.A | Each | 20 | 20 | |

2014-8-18

The delivered goods must be inspected upon receipt to confirm compliance.
Should there be discrepancies please notify METEC within 30 days of delivery.
The goods are otherwise deemed accepted.

Received by _____

**Thank you for your order!**

METEC METAL TECHNOLOGY INC.

*20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0*
*Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 metec@metec.ca*

# CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

| QUANTITY | PART NUMBER | PART NAME | P.O. NUMBER |
|---|---|---|---|
| 20 | D 4091-1P | Lug | 25276 |

MATERIAL: supplied by DART B115529

We hereby certify that the above parts were made in conformance with applicable drawings.

*METEC Metal Technology Inc.*

Jan Norris

Vankleek Hill, August 14 2014